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| DESIGN KE | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED PH | APPROVED PH | DRAWING NO. D2311 | REV. D SHEET 1 OF 2 |
| DATE 05.11.14 | | TITLE HIGH SHORT STEP ASSEMBLY | SCALE NTS |
| A | 94.11.10 | NEW ISSUE | |
| B | 97.05.22 | END CAPS CHANGED | |
| C | 97.07.23 | ADDED BUSHING AND FACING INFO | |
| D | 05.11.14 | UPDATE FINISHING NOTE | |

D2311 HIGH LONG STEP ASSEMBLY PARTS LIST

| Part No. | Description | QTY |
|--------------|-------------------------|-----|
| D2311 | High Long Step Assembly | X |
| D2244-118.0 | STEP EXTRUSION* | 1 |
| D2275 | BUSHING | 1 |
| D2582 | STEP LEG ASSEMBLY | 1 |
| D2673-34 | STEP END PLATE | 2 |
| MS20600AD4W3 | Rivets | 16 |



*cut per drawing

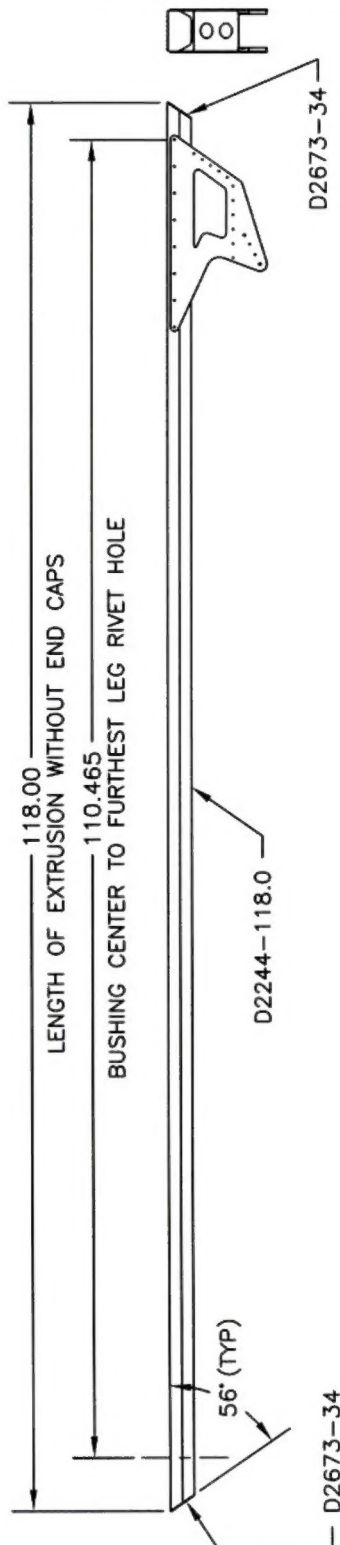
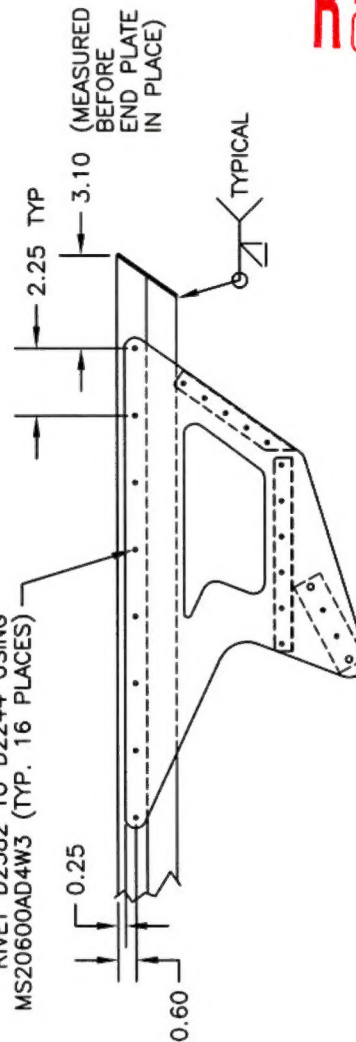
RELEASED
05.11.28 PH

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| DESIGN KE | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED  | APPROVED  | DRAWING NO. D2311 | REV. D SHEET 2 OF 2 |
| DATE 05.11.14 | TITLE HIGH LONG STEP ASSEMBLY | | SCALE NTS |

BLACK ANTI-SKID TOP SURFACE
TO BOTTOM OF TOP RADIUSD2275
BUSHING
DRILL HOLE THROUGH EXTRUSION
TO FIT $\phi 1.25$ BUSHING
WELD BUSHING INTO HOLE WITH
COUNTER BORE FACING UPFACE TOP OF STEP ON
CENTER WITH BUSHING
USING $\phi 1.875$ FACING TOOL
FACE TO REMOVE RIDGES
ON EXTRUSIONDRILL $\phi 0.128$ ON BOTH SIDES OF
D2244 TO MATCH D2582 HOLE PATTERN
RIVET D2582 TO D2244 USING
MS20600AD4W3 (TYP. 16 PLACES)**RELEASED**
05.11.28**STEP LEG DETAIL****D2311 HIGH LONG STEP ASSEMBLY**

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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